










Date: Tuesday, 02/06/2009 11:30:41 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BASKET LID ASSEMBLY
Job Number : 48311B	
Estimate Number : 10226	
P.O. Number :	Part Number : D3267043
This Issue : 02/06/2009 S.O. No. :	Drawing Number : D3267 REVC
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : LARGE FAB ASSY	Drawing Revision : C
Previous Run : 36603B	Material :
Written By :	Due Date : 10/06/2009 Qty: 1 Um: Each
Checked & Approved By : <u>JMD 09.06.02</u>	
Comment : Est Rev:C Removed -041 05-11-04 JLM Est Rev:D 08-09-10 revC as per dwg (ecn 08-524) DD verified by:EC	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
✓ 1.0	M304TS0750W065 304 SQ Tube .75x.75x.065W
	 
Comment: Qty.: 7.3500 f(s)/Unit Total : 7.3500 f(s) 3/4" x 3/4" x 0.065" wall 304/316 SS tubing Batch: <u>M111885</u> <u>SOD 09-08-15</u>	
2.0	D31663 Basket Hoop
	 
Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s) Qty 1 D3166-3 Basket Hoop Batch: <u>B44997</u> Note: D3166-3 included in D3267-041 BOM <u>PD 09.06.17</u>	
3.0	D31821 Hinge
	 
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part number Description Batch 2 D3182-1 Hinge <u>B15501</u> <u>PD 09.06.17</u>	
4.0	D34423 Shim
	 
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part number Description Batch 2 D3442-3 Shim <u>B17265</u> <u>PD 09.06.17</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BASKET LID ASSEMBLY

Job Number: 48311B

Part Number: D3267043

Job Number:



Seq. #:

Machine Or Operation:

Description :

✓ 5.0

M304EX07516F

Expanded Metal Flat SS



Comment: Qty.: 4.5150 sf(s)/Unit Total : 4.5150 sf(s)

Pick:

Qty Part number

Description

Batch

4.300sf M304EX0.75-16F Expanded Metal

M111630

SAD

09-06-15

①

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut Rib from 3/4" x 3/4" x 0.063" wall 304/316 SS tubing as per Dwg D3267

2-Cut (4) D2236-1 From D3166-3

3-Drill holes in tubing D3267-043 as per Dwg D3267

4-Deburr & Remove All Markings From Material

5-Weld D3267-043 Assembly using Welding Table and corner Jig as per Dwg D3267. Deburr as required

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid.

SD 09-06-17 ①

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

SD 09-06-17

8.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

S 09/06/17 ①

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

X PRESSURE WASH SD 09-06-17 ①

1ST

START TIME:

1:30pm

OVEN TEMPERATURE:

400°C

FINISH TIME:

2:00pm

***** 2nd coat if necessary *****

2ND COAT:

START TIME:

/

SD

09-06-17

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BASKET LID ASSEMBLY

Job Number: 48311B

Part Number: D3267043

Job Number:



Seq. #:

Machine Or Operation:

Description :

OVEN TEMPERATURE:

FINISH TIME:

el 09-06-12 *TC*

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat

BK 09-06-18 *0.*

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/19 *A*

Job Completion



MF
09-06-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X		D3267-041	BASKET LID ASSEMBLY (OUTSIDE)
	X	D3267-043	BASKET LID ASSEMBLY (INSIDE)
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
	1	D2989-1	STRUT
	1	D2989-2	STRUT
	1	D2989-3	STRUT
	1	D2989-4	STRUT
	2	D2989-5	STRUT
	2	D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
2		D3182-1	HINGE
2		D3265-3	STRUT
		D3266-7	STRUT
		D3267-1	STRUT
		D3442-3	SHIM

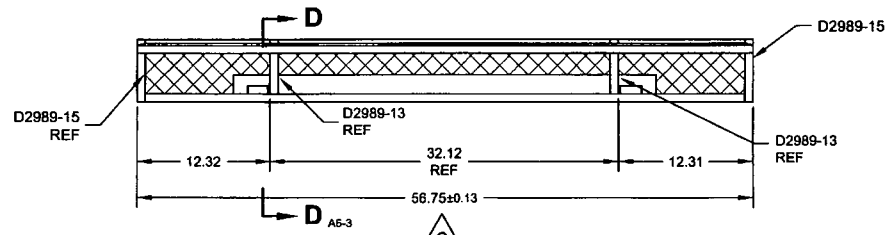
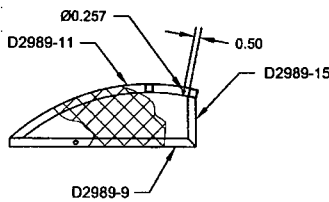
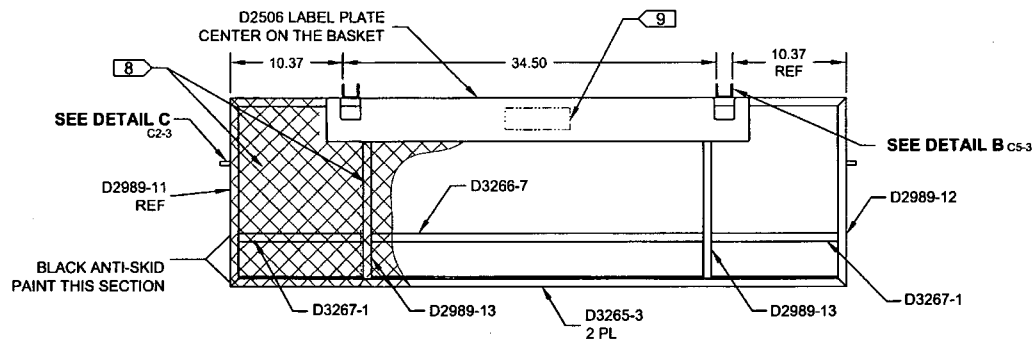
NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
(D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236)
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT INDICATED AREA PER DART QSI 005 4.4.
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004

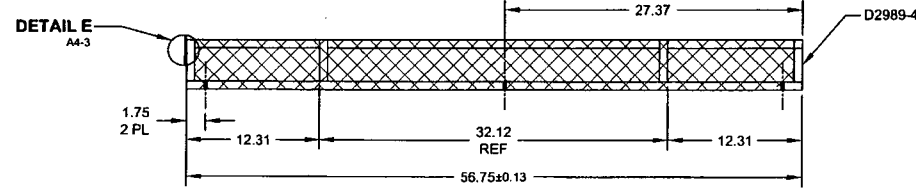
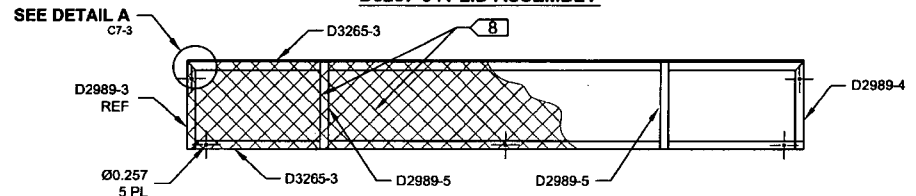
RELEASED
08-07-04-149

C	DRAWING UPDATED TO CURRENT STANDARDS. SHEET 3 ADDED. FRAME MATERIAL WALL THICKNESS WAS 0.060. D3267-1 DETAILED.	AJS	08.08.15
B	ADD SHIM UNDER HINGES	PH	05.06.08
A	NEW ISSUE	DS	04.02.02
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	ME	DRAWING NO.	REV. C
MFG. APPR.	ED	D3267	SHEET 1 OF 3
APPROVED	MM	TITLE	SCALE
DE APPR.	ME	BASKET LID ASSEMBLY	NTS
DATE	08.08.15	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1



D3267-041 LID ASSEMBLY




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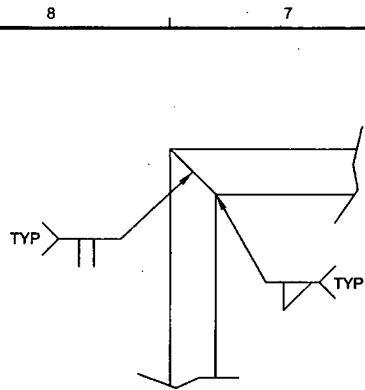
- NOTES:**
- 1) MATERIAL: SEE SHEET 1
 - 2) FINISH: SEE SHEET 1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A
 - 8) SKIN WITH EXPANDED STEEL MESH. TACK WELD MESH TO FRAME AT EVERY AVAILABLE LOCATION.
 - 9) REMOVE 2" x 6" SECTION OF MESH FROM BEHIND LABEL PLATE

RELEASED
08.07.04/17

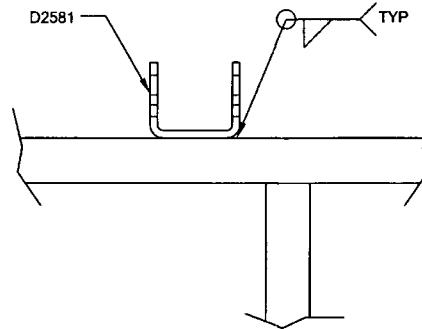
D3267-041 LID ASSEMBLY

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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D3267	2 OF 3
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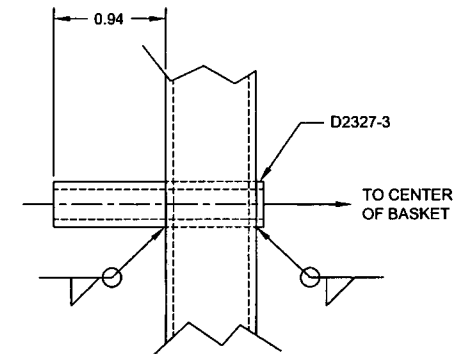
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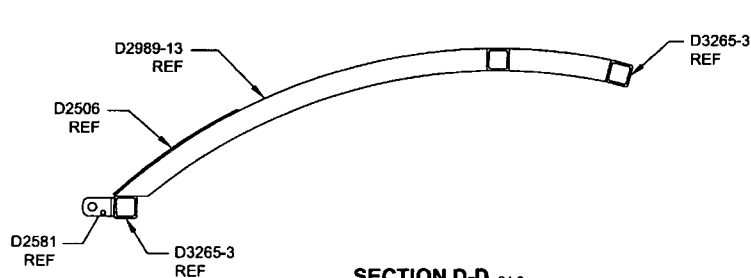
DETAIL A B5-2
JOINT WELD DETAIL TYP
SCALE 2X



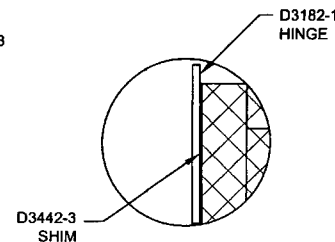
DETAIL B D2-2
2 PL
SCALE 2X



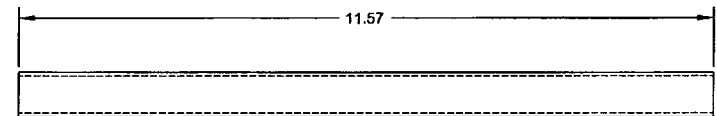
DETAIL C D5-2
SPACER INSTALLATION
SCALE 4X



SECTION D-D C4-2



DETAIL E B6-2
SCALE 2X
2 PL



D3267-1 STRUT
SCALE 2X

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08-07-15

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